

**What Is Claimed Is:**

1. A method of producing metal clamping rings for securing sleeves made of an elastic material on components which are movable relative to one another, comprising the steps of:

- 5 producing a strip portion from plate metal, the strip portion comprising strip ends which match and complement one another and which are delimited so as to be undercut-free in the longitudinal direction;
- bending the strip portion substantially circular to form a cylindrical ring with abutting strip ends; and
- welding the strip ends to form a clamping ring.

10 2. A method according to claim 1, wherein the step of producing includes cutting a coil of strip material into lengths.

3. A method according to claim 1, wherein the step of producing includes cutting the strip ends to have straight edges which extend at right angles relative to the longitudinal direction of the strip

15 portion.

4. A method according to claim 2, wherein the step of producing includes cutting the strip ends to have straight edges which extend at right angles relative to the longitudinal direction of the strip

20 portion.

5. A method according to claim 1, wherein the step of producing includes cutting the strip ends to have straight edges which extend at an angle relative to the longitudinal direction of the strip portion.

6. A method according to claim 2, wherein the step of producing includes cutting the strip ends to have straight edges which extend at an angle relative to the longitudinal direction of the strip portion.

5 7. A method according to claim 3, wherein the step of producing includes cutting the strip ends to have beveled straight edges.

8. A method according to claim 4, wherein the step of producing includes cutting the strip ends to have beveled straight edges.

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9. A method according to claim 5, wherein the step of producing includes cutting the strip ends to have beveled straight edges.

10. A method according to claim 6, wherein the step of producing includes cutting the strip ends to have beveled straight edges.

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11. A method according to claim 1, wherein the step of welding includes at least one of laser welding, plasma welding or electron-beam welding.

12. A method according to claim 3, wherein the step of welding includes at least one of laser welding, plasma welding or electron-beam welding.

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13. A method according to claim 5, wherein the step of welding includes at least one of laser welding, plasma welding or electron-beam welding.

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14. A method according to claim 1, wherein the step of welding the strip ends together includes at least one of continuously welding, stitch welding or point welding the strip ends.

5           15. A method according to claim 3, wherein the step of welding the strip ends together includes at least one of continuously welding, stitch welding or point welding the strip ends.

10           16. A method according to claim 5, wherein the step of welding the strip ends together includes at least one of continuously welding, stitch welding or point welding the strip ends.

15           17. A method according to claim 11, wherein the step of welding the strip ends together includes at least one of continuously welding, stitch welding or point welding the strip ends.

18. A method of fixing a sleeve made of an elastic material on components which are movable relative to one another, by use of a metal clamping ring, comprising the steps of:

20           producing a strip portion from plate metal, the strip portion comprising strip ends which match and complement one another and which are delimited so as to be undercut-free in the longitudinal direction;

              bending the strip portion substantially circular to form a cylindrical ring with abutting strip ends;

25           welding the strip ends to form a clamping ring;

              positioning the clamping ring on to an elastic sleeve which is positioned on one of said components; and

radially upsetting the clamping ring, with the clamping ring being permanently plastically deformed and with the sleeve being permanently elastically deformed.

19. A method according to claim 18, wherein the step of  
5 upsetting takes place mechanically by an annular tool which is divided into several segments.

20. A method according to claim 18, wherein the step of upsetting takes place electro-magnetically by annularly arranged magnetic coils.